

Work Order ID 85421

June-07-12 2:00:59 PM

ASAP

\*85421\*

Ship JUNE 18

Page 1

Item ID: D3500-1

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Saddle

Start Date: 07/06/2012 Start Qty: 40.00

\*40\*

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 40.00

\*40\*

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: 12/06/09 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3500

C

100

0.00

\*100\*

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 85421 Double check by: *SL* 1-Machine Step No 1  
per Folio FA641 and inspect per attached Dimension Sheets2-Machine Step  
No 2 per Folio FA641 and inspect per attached Dimension Sheets3-Machine  
Step No 3 per Folio FA641 and inspect p

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

*SL/SL/SL* 40  $\phi$

*SL/SL/SL* 12-06-20 (40)  $\phi$

*B.A* 12/06/21 40  $\phi$

W/O: 85421

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3500-1 PAR #: \_\_\_\_\_ Fault Category: Marking NCR: Yes No QQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: use as is QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial - Chief Eng	Action Description Chief Eng	Sign & Date			
12.06.20	100	SAMPLES # 17, 18, 19, 21: THICKNESS "AI" ARE: 0.135, 0.134, 0.132 AND 0.135 THICKNESS "AI" ARE: 0.132, 0.132, 0.135 AND 0.133 R.C. ORIGIN ORDER / PROCESS	<u>12.06.20</u> <u>Q51012</u>	PARTS ARE ACCEPTABLE, THEY MEET THE FOLLOWING REQUIREMENT Allow = 1.275" - 1.145" = 0.130" MIN AI min = 1.725" - 1.595" = 0.130" MIN	<u>12/06/21</u>	<u>12.06.21</u>	<u>12.06.20</u> <u>Q51012</u>	<u>12.06.21</u>

NOTE: Date &amp; initial all entries

# Work Order ID 85421

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**\*85421\***

Page 2

Item ID: D3500-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Saddle

Stop

**\*NS2\***

Start Date: 07/06/2012 Start Qty: 40.00

**\*40\***

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 40.00

**\*40\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

**\*130\***

HandFinish

Memo

0.00

Hand Finishing

40 x 2P 12/06/21

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*140\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

9:00

OVEN TEMPERATURE:

FINISH TIME:

9:10

40 6 142625

150

QC3- Inspect Part Finish

0.00

**\*150\***

QC

Memo

0.00

Quality Control

40 4 M 11/06/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85421

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**\*85421\***

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Item ID: D3500-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Saddle

Stop

**\*NS2\***

Start Date: 07/06/2012 Start Qty: 40.00

**\*40\***

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 40.00

**\*40\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Identify as per dwg & Stock Location: **S423** 0.00

**\*160\***

Packaging

Memo

0.00

**40x**

**SP**

Packaging

**12-6-25**

170

QC21- Final Inspection - Work Order Release 0.00

**\*170\***

QC

Memo

0.00

Quality Control

**12/6/26**

**MP**  
**12-06-25**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-07-12 2:01:03 PM

Page 1

Work Order ID: 85421

\*85421\*

Parent Item: D3500-1

\*D3500-1\*

Parent Item Name: Saddle

Start Date: 07/06/2012

Required Date: 14/06/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013		Manufactured	No			100	Each	32.0000	1	40			

\*D6102-013\*

\*\*

Saddle Billet

Location

Loc Qty

Loc Code

MAT043

12

59467

3

60713

8

61300

1

MAT045

20

~~8~~3684

20

20

B85 430 X 20

amk 12/06/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 85421	
<b>Description:</b> Saddle				<b>Part Number:</b> D3500-1	
<b>Inspection Dwg:</b> D3500				<b>Rev:</b> C	
				<b>Page 1 of 1</b>	

				<b>Recorded Actual Dimensions</b>					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.366	.375	.375	.375		
F	0.490	0.510		.498	.499	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.584	1.595	1.593	1.592		
J	0.240	0.260		.254	.243	.247	.250		
K	0.490	0.510		.498	.499	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.552		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.060	.055	.055	.055		
Y	0.100	0.120		.105	.110	.110	.110		
AA	R1.125	R1.145		1.129	1.140	1.137	1.1378		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.256	.246	.252	.253		
AE	1.810	1.830		1.820	1.822	1.821	1.822		
AF	0.240	0.260		.252	.253	.253	.255		
AG	0.140	0.160		.151	.155	.155	.154		
AH	0.140	0.160		.150	.143	.146	.153		
AI	0.140	0.160		.153	.145	.150	.155		
<b>Accept/Reject</b>									

Measured by:	anf
Date:	12/06/16

Audited by:	N.A
Date:	12/06/21

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

DART AEROSPACE LTD				Work Order: 85421	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	37	48	By	Date
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.591	1.591	1.588	1.589		
J	0.240	0.260		.251	.251	.254	.252		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.553	.556	.5515	.551		
V	0.793	0.803		.794	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.055	.055	.055	.055		
Y	0.100	0.120		.110	.105	.105	.110		
AA	R1.125	R1.145		1.1365	1.137	1.134	1.134		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.253	.253	.253	.251		
AE	1.810	1.830		1.821	1.821	1.826	1.823		
AF	0.240	0.260		.255	.254	.255	.253		
AG	0.140	0.160		.155	.155	.153	.152		
AH	0.140	0.160		.153	.153	.155	.157		
AI	0.140	0.160		.153	.153	.155	.157		
Accept/Reject									

Measured by: <i>amf / st</i>
Date: 12/06/16

Audited by: <i>R.A</i>
Date: 12/06/16

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	<i>AA</i>

DART AEROSPACE LTD				Work Order: 85421	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	X9	Z10	X11	X12	By	Date
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.585	1.5869	1.587	1.594		
J	0.240	0.260		.257	.256	.256	.248		
K	0.490	0.510		.501	.501	.500	.501		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.005	6.004	6.004	6.004		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.552	.552	.553	.552		
V	0.793	0.803		.798	.798	.798	.800		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.055	.055	.055	.055		
Y	0.100	0.120		.105	.105	.105	.105		
AA	R1.125	R1.145		1.131	1.133	1.132	1.139		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.258	.256	.257	.253		
AE	1.810	1.830		1.822	1.823	1.822	1.821		
AF	0.240	0.260		.254	.254	.254	.255		
AG	0.140	0.160		.151	.152	.150	.154		
AH	0.140	0.160		.157	.155	.155	.155		
AI	0.140	0.160		.157	.156	.156	.154		
Accept/Reject									

Measured by: <i>amr / JJ</i>	
Date: 12/06/17	

Audited by: <i>B.A.</i>	
Date: 12/06/17	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	<i>AA</i>

DART AEROSPACE LTD				Work Order:	85421
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500				Rev: C	Page 1 of 1

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1/3	2/4	3/5	4/6		
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.5883	1.590	1.590	1.590		
J	0.240	0.260		.254	.253	.253	.253		
K	0.490	0.510		.500	.501	.501	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.004	6.004	6.004	6.004		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.549	.552	.551	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.055	.055	.055	.055		
Y	0.100	0.120		.105	.105	.105	.105		
AA	R1.125	R1.145		1.1345	1.136	1.1356	1.1358		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.256	.253	.254	.254		
AE	1.810	1.830		1.825	1.825	1.824	1.824		
AF	0.240	0.260		.255	.254	.254	.254		
AG	0.140	0.160		.154	.153	.151	.152		
AH	0.140	0.160		.155	.155	.158	.147		
AI	0.140	0.160		.155	.155	.156	.152		
Accept/Reject									

Measured by:	SA
Date:	12/06/17

Audited by:	M.A
Date:	12/06/21

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	SA

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	85421
<b>Description: Saddle</b>		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg: D3500</b>		<b>Rev: C</b>	<b>Page 1 of 1</b>

				<b>Recorded Actual Dimensions</b>					
Dim	Min	Max	Go/No Go Gauge	X17	X18	X19	X20	By	Date
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.5873	1.590	1.5826	1.5858		
J	0.240	0.260		.254	.252	.257	.256		
K	0.490	0.510		.501	.500	.500	.501		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.004	6.004	6.004	6.004		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.551	.548	.553		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.055	.055	.055	.055		
Y	0.100	0.120		.105	.105	.105	.105		
AA	R1.125	R1.145		1.135	1.135	1.127	1.1342		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.254	.254	.260	.260		
AE	1.810	1.830		1.823	1.822	1.822	1.821		
AF	0.240	0.260		.254	.254	.254	.254		
AG	0.140	0.160		.151	.151	.151	.153		
AH	0.140	0.160	.135	.137	.134	.137	.154		
AI	0.140	0.160	.137	.137	.137	.138	.143		
<b>Accept/Reject</b>									

Measured by:	JL
Date:	12/04/17

Audited by:	J.A
Date:	12/06/21

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	JA

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	85421
<b>Description:</b> Saddle		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg:</b> D3500		<b>Rev:</b> C	<b>Page 1 of 1</b>

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	121	222	23	24	By	Date
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is .015" over flange)									
I	R1.575	R1.595		1.5845	1.5818	1.5877	1.586		
J	0.240	0.260		.255	.260	.255	.255		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.004	6.003	6.003	6.003		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.1304	1.1262	1.1329	1.1314		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.260	.262	.260	.260		
AE	1.810	1.830		1.822	1.823	1.824	1.824		
AF	0.240	0.260		.253	.253	.253	.253		
AG	0.140	0.160		.151	.151	.153	.151		
AH	0.140	0.160		.135	.148	.155	.150		
AI	0.140	0.160		.133	.152	.145	.148		
Accept/Reject									

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>
Date:	12/06/18	Date:	12/06/21

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	85421
<b>Description: Saddle</b>		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg: D3500</b>		<b>Rev: C</b>	<b>Page 1 of 1</b>

				<b>Recorded Actual Dimensions</b>					
Dim	Min	Max	Go/No Go Gauge	125	226	327	428	By	Date
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.152	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.5861	1.587	1.588	1.589		
J	0.240	0.260		.255	.255	.252	.252		
K	0.490	0.510		.501	.501	.500	.501		
L	3.590	3.650		3.620	3.600	3.600	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.004	6.004	6.004	5.999		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.551	.555	.554	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.1342	1.132	1.133	1.134		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.256	.257	.257	.255		
AE	1.810	1.830		1.824	1.823	1.822	1.821		
AF	0.240	0.260		.255	.252	.252	.252		
AG	0.140	0.160		.152	.150	.149	.150		
AH	0.140	0.160		.155	.153	.153	.153		
AI	0.140	0.160		.153	.155	.155	.154		
<b>Accept/Reject</b>									

Measured by:	JA
Date:	12/06/18

Audited by:	B.A
Date:	12/06/21

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	JA

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	85421
<b>Description: Saddle</b>		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg: D3500</b>		<b>Rev: C</b>	<b>Page 1 of 1</b>

				<b>Recorded Actual Dimensions</b>					
Dim	Min	Max	Go/No Go Gauge	129	230	331	432	By	Date
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.498	.501	.500	.499		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.587	1.587	1.587	1.587		
J	0.240	0.260		-.250	-.250	-.250	-.250		
K	0.490	0.510		-.500	-.500	-.500	-.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		-.316	-.316	-.316	-.316		
N	0.256	0.262		-.258	-.258	-.258	-.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		-.550	-.550	-.550	-.550		
V	0.793	0.803		-.798	-.798	-.798	-.798		
W	R.240	R.260		-.250	-.250	-.250	-.250		
X	0.040	0.060		-.050	-.050	-.050	-.050		
Y	0.100	0.120		-.110	-.110	-.110	-.110		
AA	R1.125	R1.145		1.133	1.133	1.133	1.133		
AB	R.490	R.510		-.500	-.500	-.500	-.500		
AC	0.615	0.635		-.630	-.630	-.630	-.630		
AD	0.240	0.260		-.253	-.253	-.253	-.253		
AE	1.810	1.830		1.818	1.820	1.820	1.820		
AF	0.240	0.260		-.249	-.249	-.249	-.249		
AG	0.140	0.160		-.149	-.149	-.149	-.148		
AH	0.140	0.160		-.157	-.156	-.155	-.154		
AI	0.140	0.160		-.156	-.155	-.155	-.155		
<b>Accept/Reject</b>									

Measured by:	J
Date:	12-06-19

Audited by:	H. A
Date:	12/06/21

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA



<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 85421	
<b>Description:</b> Saddle				<b>Part Number:</b> D3500-1	
<b>Inspection Dwg:</b> D3500				<b>Rev:</b> C	
				<b>Page 1 of 1</b>	

				<b>Recorded Actual Dimensions</b>					
Dim	Min	Max	Go/No Go Gauge	1/33	2/34	3/25	4/36	By	Date
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.498	.498	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.586	1.587	1.589	1.587		
J	0.240	0.260		.250	.250	.249	.250		
K	0.490	0.510		.501	.501	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.133	1.133	1.134	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.252	.251	.250	.252		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.250	.249	.249	.249		
AG	0.140	0.160		.148	.149	.150	.150		
AH	0.140	0.160		.155	.155	.157	.155		
AI	0.140	0.160		.157	.156	.155	.155		
<b>Accept/Reject</b>									

Measured by:	SL
Date:	12-06-19

Audited by:	J.A
Date:	12/06/21

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	85421
<b>Description: Saddle</b>		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg: D3500</b>	<b>Rev: C</b>	<b>Page 1 of 1</b>	

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				137	238	331	440		
A	0.483	0.490		486	486	486	486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		375	375	375	375		
F	0.490	0.510		500	500	499	500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.588	1.588	1.588		
J	0.240	0.260		248	249	250	249		
K	0.490	0.510		500	500	500	500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		316	316	316	316		
N	0.256	0.262		258	258	258	258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		550	550	550	550		
V	0.793	0.803		798	798	798	798		
W	R.240	R.260		250	250	250	250		
X	0.040	0.060		0.50	0.50	0.50	0.50		
Y	0.100	0.120		110	110	110	110		
AA	R1.125	R1.145		1.134	1.133	1.133	1.133		
AB	R.490	R.510		500	500	500	500		
AC	0.615	0.635		630	630	630	630		
AD	0.240	0.260		251	253	253	252		
AE	1.810	1.830		1.819	1.820	1.820	1.820		
AF	0.240	0.260		248	249	248	249		
AG	0.140	0.160		149	150	150	150		
AH	0.140	0.160		154	156	156	155		
AI	0.140	0.160		155	155	155	156		
Accept/Reject									

Measured by:	SL
Date:	12-06-19

Audited by:	BS
Date:	12/06/21

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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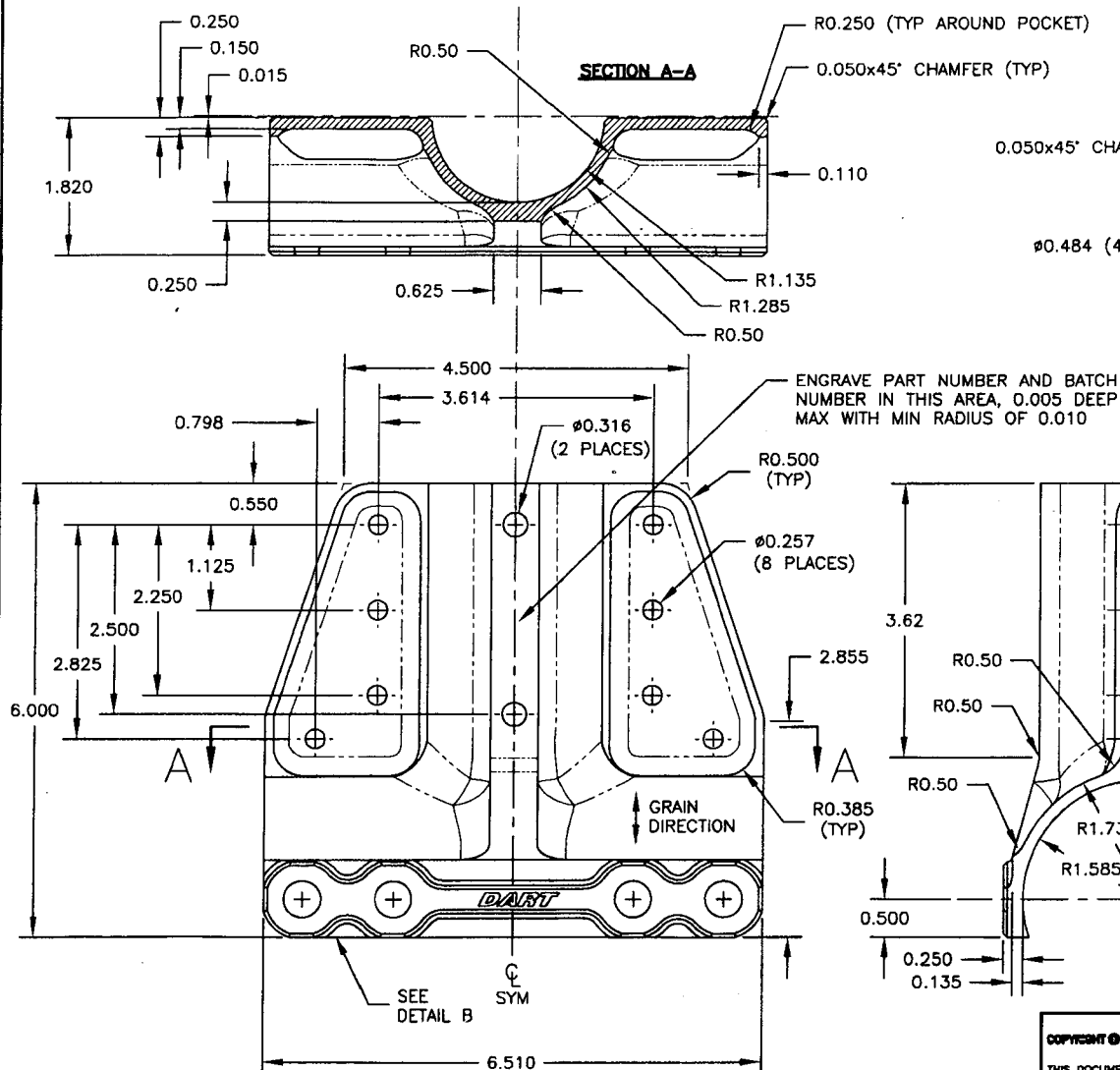
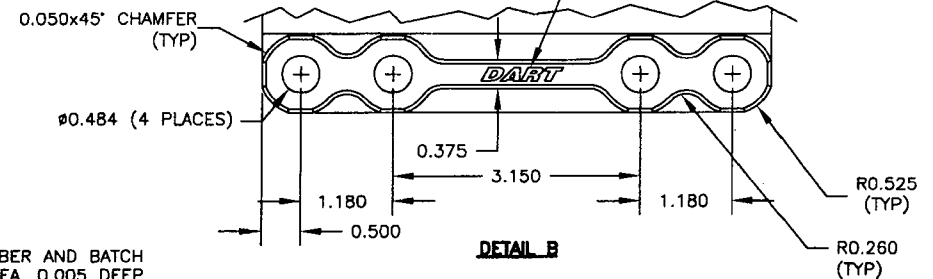
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 85421 M L J  
12/06/07

ENGRAVE DART LOGO IN  
THIS AREA TO A MAX  
DEPTH OF 0.015 AND A MIN.  
TOOL RADIUS OF 0.250



### D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11)  
(MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1,  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.08.15 #

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	PH	DART DART AEROSPACE LTD. WARRICKBURT, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3500
DATE	06.06.30	TITLE SADDLE
		REV. C SHEET 1 OF 1 SCALE 2:3

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries